

Date: Wednesday, 06/09/2006 11:05:26 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASS'Y
 Job Number : 28425
 Estimate Number : 12523
 P.O. Number : N/A
 This Issue : 06/09/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : N/A
 Written By : EE
 Checked & Approved By :
 Comment : Est Rev:A New Issue 06-09.06 EC

Part Number : D35313
 Drawing Number : UNDER REVIEW EE 06.09.05
 Project Number : N/A
 Drawing Revision : N/A
 Material : N/A
 Due Date : 13/09/2006 Qty: 2 Um: Each

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6S040 6061-T6 .040 Sheet



Comment: Qty: 0.1379 sf(s)/Unit Total: 0.2757 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: ML 06 09 06

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3531

Dwg Rev: PreProg Rev: Pre

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE ML 06 09 06

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK EE 06 09 06

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SD06 / 09 / 12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: R Date: 21/9/04
 DQA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/09/2006 11:05:26 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASS'Y

Job Number: 28425

Part Number: D35313

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3530

SB

06/09/12

(2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

am 06-08-14

(2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

R

06.09.14

(2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Check for eng. use only.

Location: _____

R

06.09.19

(2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Inspection Level 21

K

(2)

□

Job Completion



W 06.09.20

PART WENT TO HAI . PART IS NOT APPROVED AND NOT AIRWORTHY

CB 07.07.13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-07-13	6-1	Add QC 5 perm change						
		QC 5 inspect + work	2	06-05-13	2			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

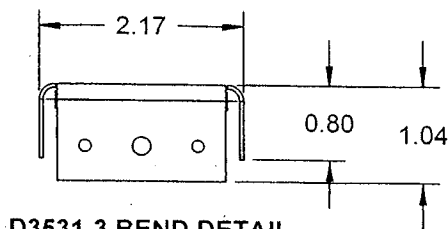
NOTE: Date & initial all entries

PRELIMINARY ISSUE

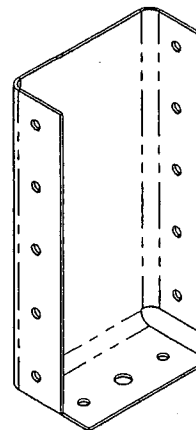
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3531	REV. A SHEET 3 OF 3
DATE 06.06.21	TITLE BRACKET ASSEMBLY SCALE 1:2		

UNDER REVIEW

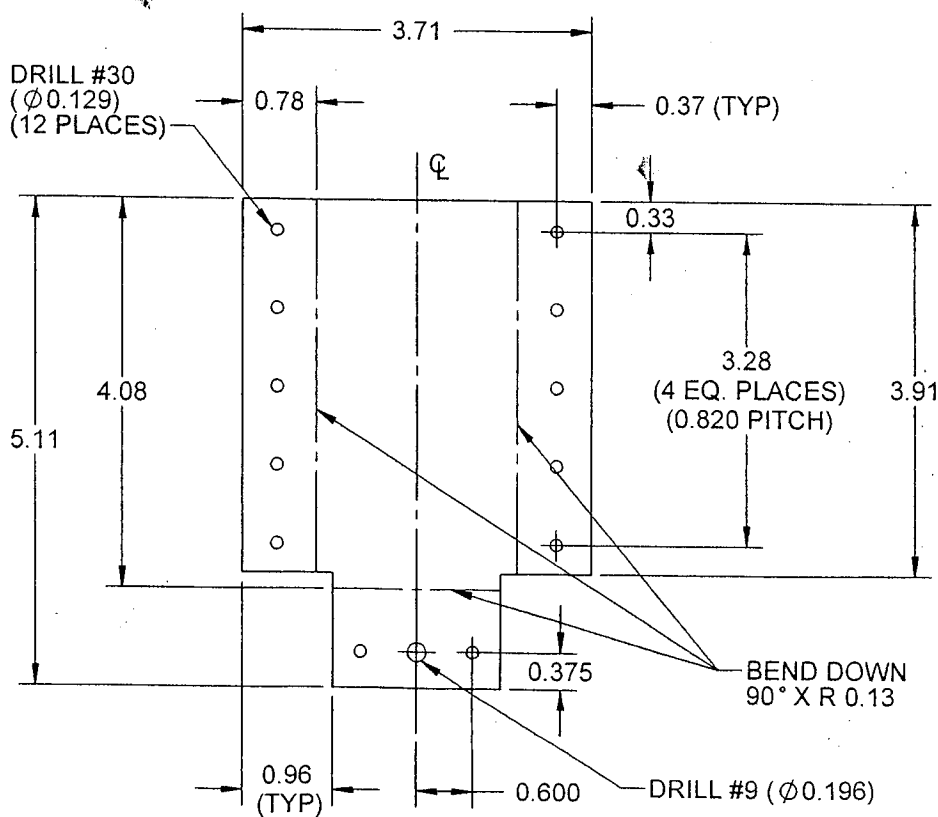
06-08-22 CB
prototype



D3531-3 BEND DETAIL



D3531-3 BEND DETAIL



D3531-3F FLAT PATTERN

D3531-3 BRACKET FRONT PLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.040" SHEET (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT ϕ

EST Done
Pros

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DOC : V/0080151422

DATUM : 2005-04-18

PROD. REF. : 0000175932/001

NRBST : 58848/01

PAGINA : 1/ 1

KEURINGSRAPPORT



KLANT : COPPER AND BRASS SALES
CORPORATE SERVICES DIVISION
SOUTHFIELD, MI USA

UW ORDERNUMMER : PO3944 (COPPER'S PO#CC1837)
ONS ORDERNUMMER : 58848/01
DOCUMENT NUMMER : V/0080151422

Corus Aluminium N.V.
A Stedelaan 87, 2570 Duffel - Belgium
Tel. 32 (0)15 30 21 11 - Fax (0)15 30 27 94

SPECIFICATIES: ALU SHEETS (STENC.) AA 6061-T6 AMS-QQA-250/11 AMS 4027M ASTM B209-04
AFMETINGEN : 144" X 48" X 0,04"
ARTIKEL NR. :

ROL- NUMMER	GEUT- NUMMER	CHEMISCHE ANALYSE (%)								
		MIN	SI	FE	CU	MN	MG	CR	TI	ZN
		MAX	0,40		0,15		0,8	0,04		
			0,8	0,7	0,40	0,15	1,2	0,35	0,15	0,25
001	7124901		0,67	0,4	0,22	0,09	1,1	0,16	0,02	0,01
002	7124901		0,67	0,4	0,22	0,09	1,1	0,16	0,02	0,01
ANDERE : ELK		:			MIN	0,05 MAX				
TOTAAL		:			MIN	0,15 MAX				

TEST- NUMMER		MECHANISCHE EIGENSCHAPPEN			
		1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI			
		/A = ACHTER /M = MIDDEN /V = VOOR /O = RANDOM			
		MIN	RM	RP02	A
		MAX	KSI	KSI	%
			42	35	10
001	/A		47	39	16
001	/M		47	39	15
001	/V		47	39	16
002	/A		47	39	16
002	/M		48	40	16
002	/V		48	39	16

COPPER AND BRASS SALES

SOLD TO: 193

DATE: 12/16 QTY. 22

CUSTOMER PO: 0000004

SHIPPER NO: 4V3428

BY: 8

08-6-14

Corus Aluminium Rolled Products - Corus Aluminium Extrusions